

Work Order ID 73585

Tuesday, September 06, 2011 8:58:21 AM



Page 1

Item ID: D3281-4L02

Accept



Setup Start



Revision ID:

Item Name: Floor Protector, Aft RH (Black)

Stop



Start Date: 9/6/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/14/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *V*
QC:Date:
Date:Tooling:
SPC (Y/N):Date:
Date:Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3281	Rev F
DSI 9504	A

100 0.00

HAND FINISHING THERMOFORMING

Thermoform Memo 0.00

Thermoforming Machine Cut Blanks

105 0.00

Dry Material

HandThermo Memo 0.00

Hand Finishing Thermoforming Dry Sheet as per QSI022 POLYCARBONATE

Temp: *240° F*Time IN: *4:30 pm* 11/09/07Time OUT: *7:00 pm* 11/09/08*x2**dc
11/09/08**x2**dc
11/09/08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Required Date: 9/14/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

110

Operation
Description

THERMOFORMING MACHINE

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D3281 and Folio FTA 010

Dwg. Rev. EFolio Rev. D

2

JL
11/09/08

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

2

JL
11/09/08

130



HAND FINISHING THERMOFORMING

0.00

Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions

2

JL
11/09/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73585

Tuesday, September 06, 2011 8:58:21 AM



Page 3

Item ID: D3281-4L02

Accept



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Item Name: Floor Protector. Aft RH (Black)

Stop



Start Date: 9/6/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/14/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

140



QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

QC2- Inspect parts off machine FAI/FAIB

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Work Order ID 73585

Tuesday, September 06, 2011 8:58:21 AM



Page 4

Item ID: D3281-4L02

Accept



Setup Start



Revision ID:

Item Name: Floor Protector, Aft RH (Black)

Stop



Start Date: 9/6/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/14/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

170



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11/9/14 J

Memo

0.00

11/10/13
(2)

Picklist Print

Tuesday, September 06, 2011 8:58:18 AM

Page 1

Work Order ID: 73585



Parent Item: D3281-4L02



Parent Item Name: Floor Protector, Aft RH (Black)

Start Date: 9/6/2011

Required Date: 9/14/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 04.07.01 New issue. KJ/JLM

IPP Rev. C

IPP Rev B 07.08.07 Thermoform in house DL

ADD Step 105 Dry Material 10/04/21 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MLEXS.093-F6006-02

Purchased

No

sf 685.2916

8.666

GE PLASTICS LEXAN SHEET

Location	Loc Qty	Loc Code
therm	685.29158	
106751	105.89	
110877	579.40158	

8.666 sq ft.

W
11/08/08.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <i>73585</i>
Description: Floor Protector, Aft RH	Part Number:	D3281-4
Inspection Dwg: D3281	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: *DB*

Date: *11/09/08*

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.8	+/-0.100	17.8"	✓		TAPE DL-01	
17.1	+/-0.100	17.1"	✓		TAPE DL-01	
14.3	+/-0.100	14.3"	✓		TAPE DL-01	
0.95	+/-0.030	0.966"	✓		Open TIR-01	
0.050	Min	0.063	✓		Open TIR-01	
0.070	Min	0.081	✓		ULTRA	

Measured by: *DB*

Date: *11/09/08*

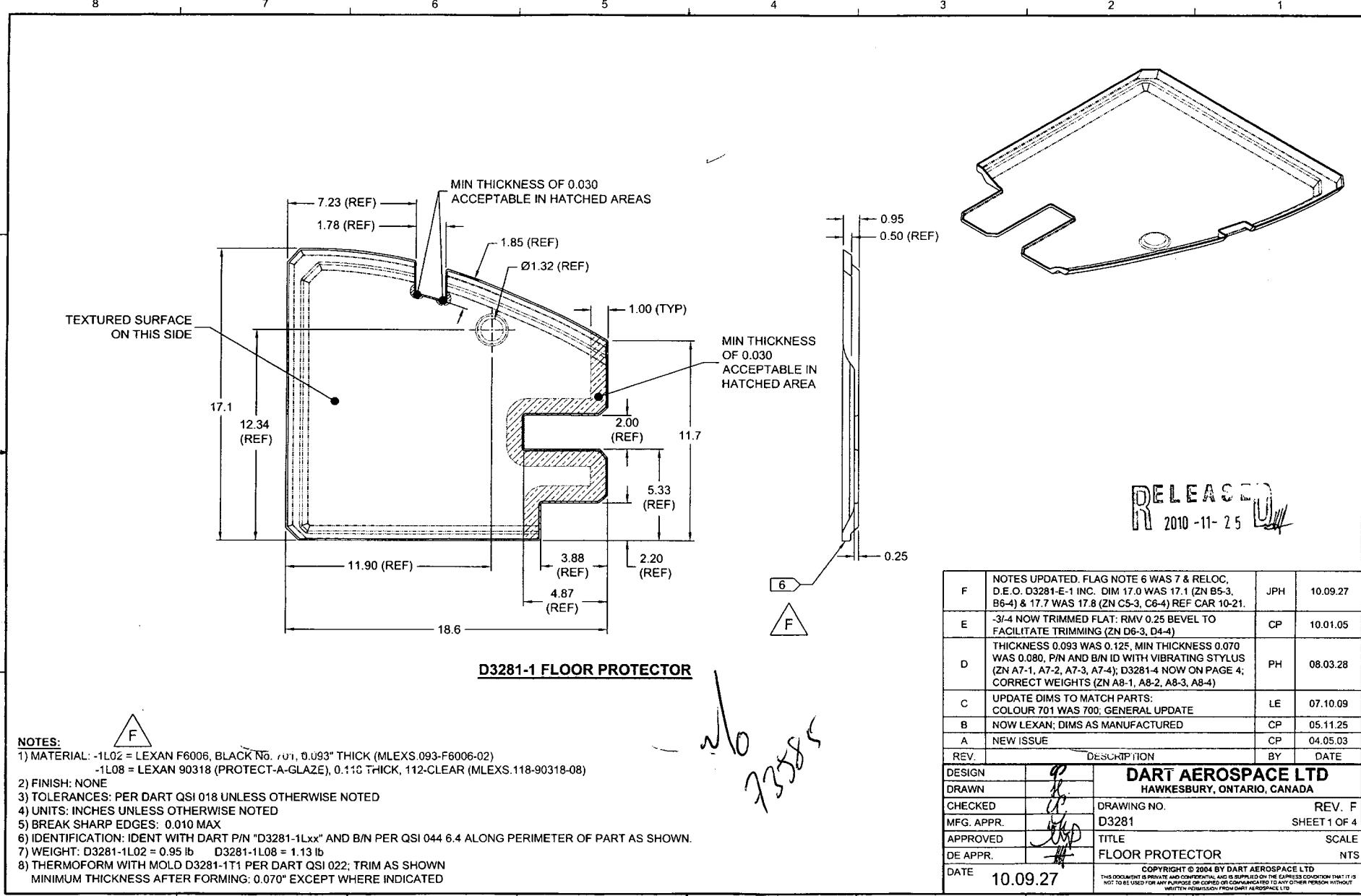
Audited by: *DB*

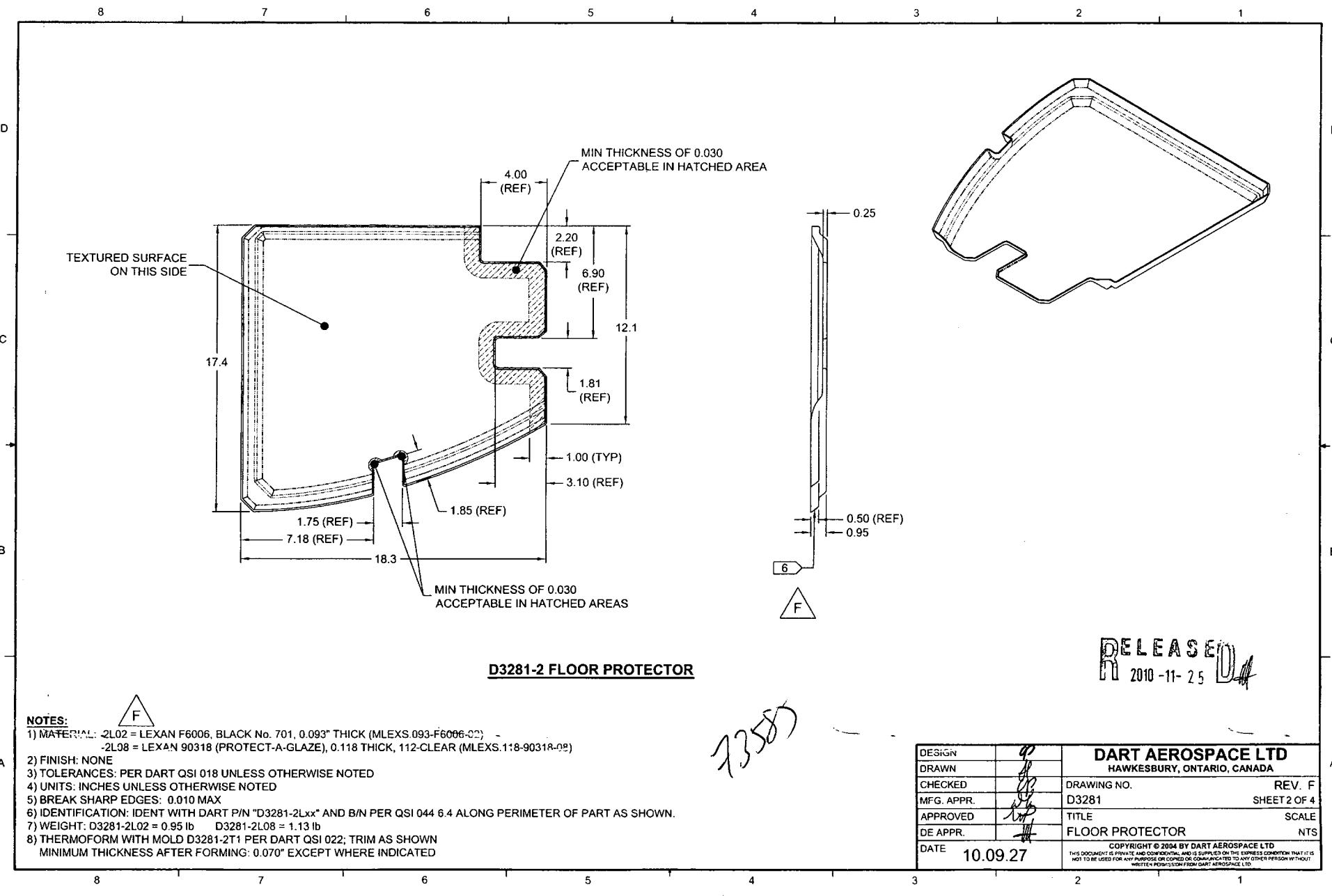
Date: *11/09/12*

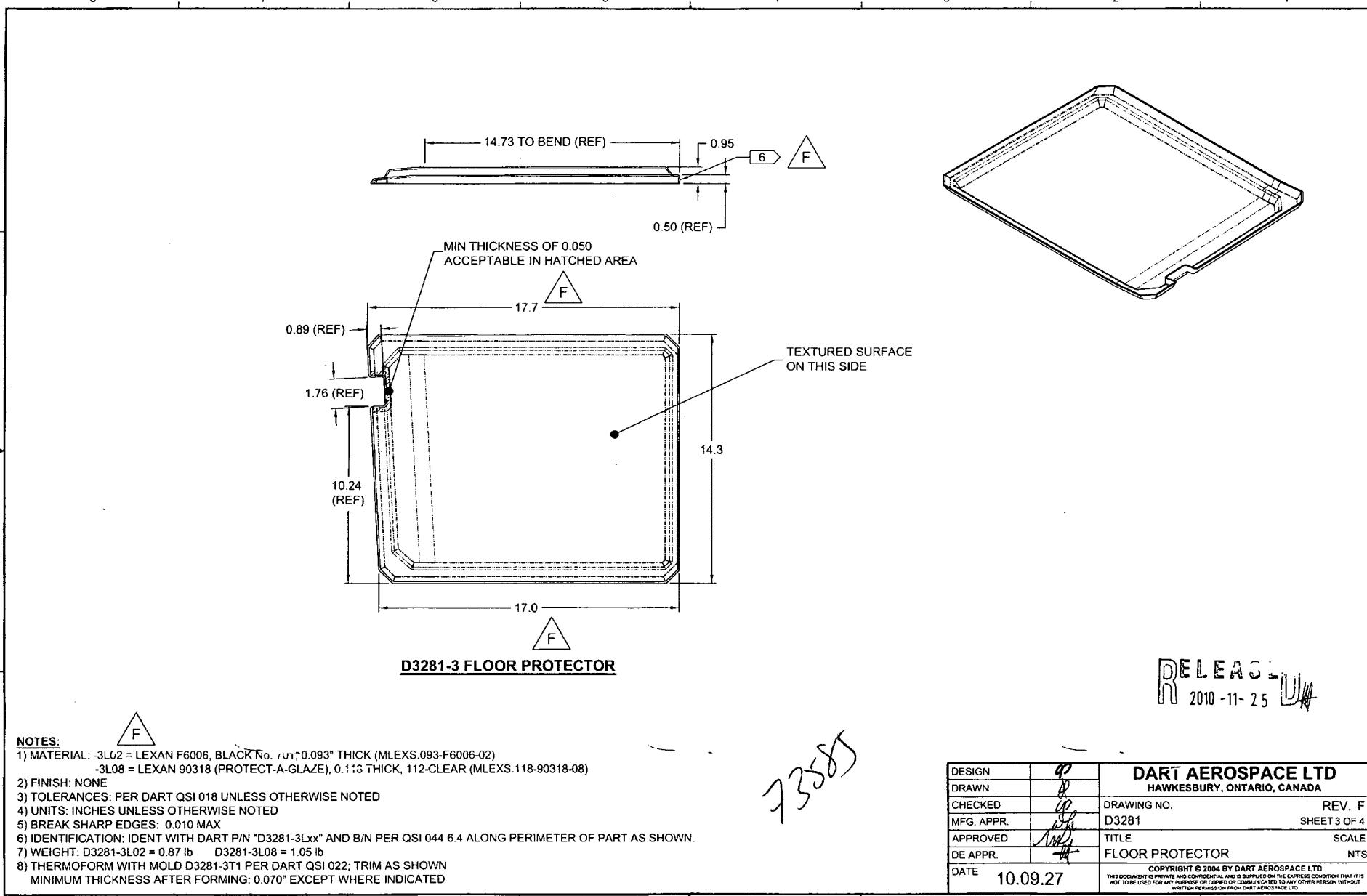
Preliminary Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	
C	10.09.01	Dimensions updated per Dwg Rev E	KJ	
D	11.06.21	Dwg Rev updated	KJ	<i>DB</i> <i>JK</i>





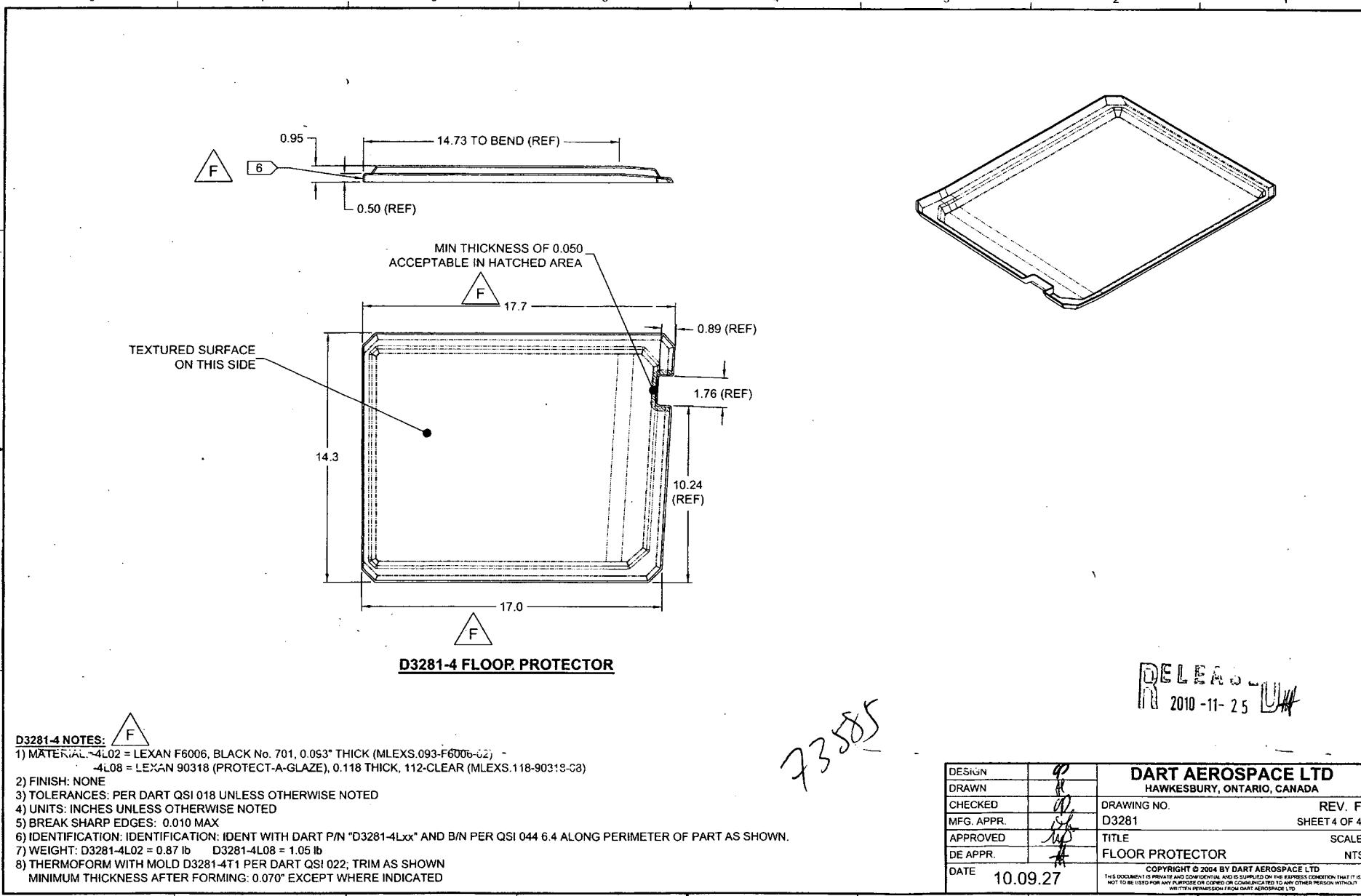


RELEASED
2010-11-25 BY [Signature]

NOTES:

1) MATERIAL: -3L02 = LEXAN F6006, BLACK NO. 1/16" 0.093" THICK (MLEXS.093-F6006-02)
-3L08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.116 THICK, 112-CLEAR (MLEXS.118-90318-08)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.010 MAX
6) IDENTIFICATION: IDENT WITH DART P/N "D3281-3Lxx" AND B/N PER QSI 044 6.4 ALONG PERIMETER OF PART AS SHOWN
7) WEIGHT: D3281-3L02 = 0.87 lb D3281-3L08 = 1.05 lb
8) THERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED

DESIGN	99	DART AEROSPACE LTD	
DRAWN	8	HAWKESBURY, ONTARIO, CANADA	
CHECKED	00	DRAWING NO.	REV. F
MFG. APPR.	SP	D3281	SHEET 3 OF 4
APPROVED	10/27	TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	
DATE	10.09.27	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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23585

DESIGN	<i>P</i>	DART AEROSPACE LTD	
DRAWN	<i>8</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>10</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>10</i>	D3281	SHEET 4 OF 4
APPROVED	<i>10</i>	TITLE	SCALE
DE APPR.	<i>10</i>	FLOOR PROTECTOR	NTS
DATE	10.09.27	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CONVEYED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	